CHS062

Extra-low Carbon Stainless Steel Covered Welding Rod

AWS A5.4 E309L-16
ISO 3581-A-E (23 12 L) R 3 2
ISO 3581-B-ES309L-16
BS EN 1600-E 23 12 L R 3 2
CSA W48 E309L-16
JIS Z3221 D309L-16
GB/T 983 E309L-16

Type of Covering: Lime-titania
Welding Position: F, H, HF, OH, V
Type of Current: DCEP or AC

Features & Applications

It is suitable for welding structures fabricated by similar extra-low carbon stainless steels or for welding structures fabricated by ply steels and dissimilar steels. Also it could be used for surfacing lining intermediate layer of pressure vessels of nuclear reactor. The weld metal has good resistance to weld intercrystalline corrosion although there is no niobium and titanium.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	≤0.04	0.50-2.50	≤1.00	22.0-25.0	12.0-14.0	≤0.75	≤0.75	≤0.03	≤0.04
Atlantic	0.027	0.85	0.67	24.20	13.09	0.09	0.092	0.009	0.020

Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥520	≥30
Atlantic	565	41

Sizes Pieces & Recommended Current (DC+ or AC)

Size (mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	F, H	50-70	80-110	130-160	160-220
	V, OH	45-60	70-100	110-140	—

Approvals

Institute	CWB
Grade	CSA W48 E309L-16

Notice: 1) The rod should be baked at 300℃ -350℃ for 1 hour before use.

2) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.

3) Smaller current and short arc are recommended in welding and weave beads no wider than 2.5 times of the diameter of the core rod is better.